

Work Order ID 69292-2

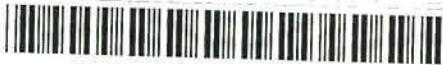
Friday, May 06, 2011 11:55:39 AM



Page 1

Item ID: D3537-3

Accept



Setup

Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 5/6/2011 Start Qty: 12.00



Required Date: 5/9/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

SL

Date: 11/05/11

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100



FLOW WATER JET

0.00

Waterjet

Memo

0.00

11/11-5-9

FLOW CNC Waterjet

304.063

I-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

11/11-5-9

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

SL 11/05/09

(15)

Work Order ID 69292

Friday, May 06, 2011 11:55:40 AM



Page 2

Item ID: D3537-3

Accept



Setup



Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 5/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

130



Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Brake NC

Brake NC

Memo

0.00

15

SB 11/05/09

140



QC5- Inspect part completeness to step on W/O

0.00

5/10/09

QC

Quality Control

Memo

0.00

70

Ensure joggle as per dwg D3429

150



Large Fab

0.00

Pto →

Large Fab

Large Fab

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
Weld hardcoat as per Dwg D3437

M117607

X/4 11-6-14

E/13C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DB537-3 PAR #: W/A Fault Category: Large Fab- welding NCR: Yes No DQA: A Date: 11-06-16
 11-06-16
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11-06-17

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-06-14	150	Qty x2 Scrap due to welder training R.L. training Employee	W/A 11-06-14	Scrap + Destry no Reper	JBL 11-6-14 EL 11-6-14	S 11-06-14	A 11-06-14	S 11-06-14

NOTE: Date & Initial all entries

Work Order ID 69292

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Item ID: D3537-3

Accept



Setup



Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 5/6/2011 Start Qty: 12.00



Required Date: 5/9/2011 Req'd Qty: 12.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/

Work Center ID

160



QC

Quality Control

Operation

Description

QC10- Inspect visual per QSI004- ground welds

Memo

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S ualoc/14

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S ualoc/14

(Y12)

180



Powdercoat

Powder Coating

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

0.00

Memo

START TIME:

8:50

0.00

OVEN TEMPERATURE:

FINISH TIME:

320⁰F

9:20

12x Ø m-11/06/16

M 11/5/12

Work Order ID 69292

Friday, May 06, 2011 11:55:40 AM



Page 4

Item ID: D3537-3

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 5/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID
190

QC

Quality Control

Operation
Description
QC3- Inspect Part FinishSet Up/
Run Hours
0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Packaging
Packaging

Identify as per dwg & Stock Location:

F-P 19

0.00

Memo

0.00

12 4 11/06/16

12 X 8 M 11/06/16

210

QC
Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/06/16

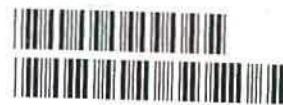
MF
11-06-16

Printlist Print

Friday, May 06, 2011 11:55:48 AM

Page 1

Work Order ID: 69292



Parent Item: D3537-3



Parent Item Name: Wearpad

Start Date: 5/6/2011

Required Date: 5/9/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	98.5000	0.149	1.882105	0.5	131-5-7	

Location	Loc Qty	Loc Code
MAT020	98.5	
117275	98.5	17025

15

DART AEROSPACE LTD	Work Order:	69382
Description: Wearpad	Part Number:	D3537-3
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by: B
Date: 11-5-9

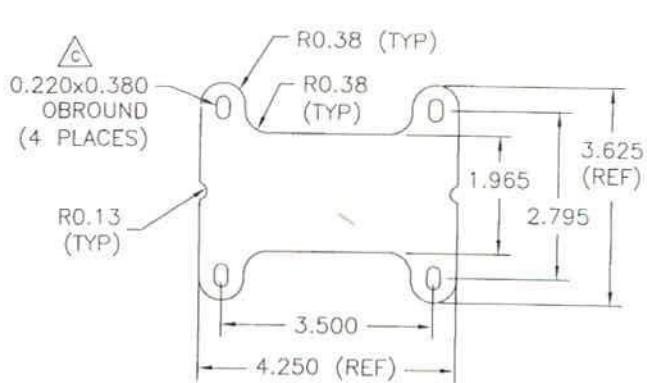
Audited by: 8
Date: 11/07/08

Prototype Approval:	N/A
Date:	N/A

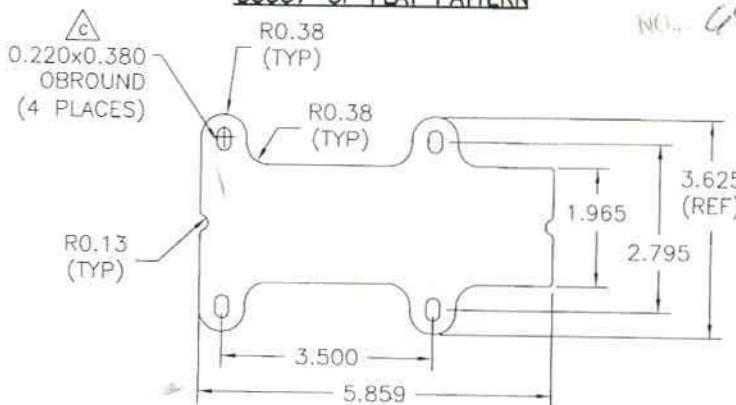
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

100-054
by 3.000
outboard
WIR CONTR
SOLID 100%
WITHOUT REIN
WORK 100%
NO. 68292

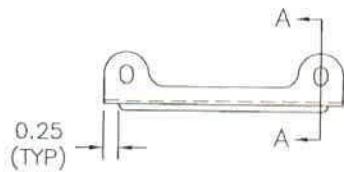
D3537-1F FLAT PATTERN



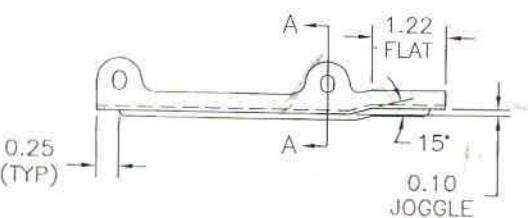
D3537-3F FLAT PATTERN



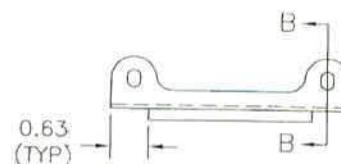
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

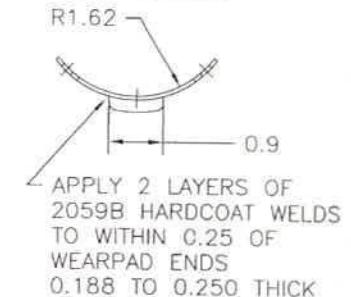
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	4	APPROVED 4
DRAWING NO.	D3537	REV. C
DATE	07.04.13	SHEET 1 OF 1
TITLE	WEARPAD	SCALE 1:2

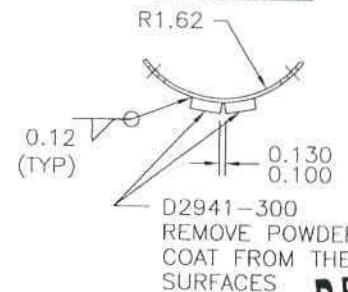
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SECTION A-A



SECTION B-B



RELEASED
07.05.08 AM
per E&N

D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)

